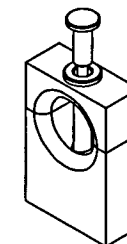
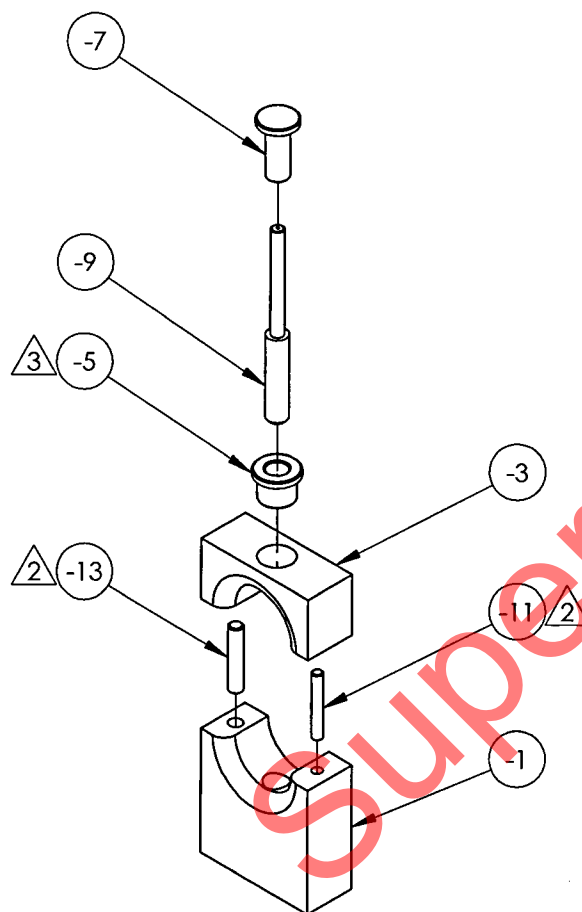


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 REMOVED B/O INFORMATION AND SPECIFICATION. MATERIAL WAS STEEL IS O1, DIM WAS (Ø .625) IS Ø .6250 +.0017/+ .0014. DIM WAS (Ø .375) IS Ø .3750 +.0005/+ .0001. DIM WAS (Ø .797) IS Ø .80. DIM WAS 3X .03 X 45° IS 4X .03 X 45°.	18/10/2018	KPT	



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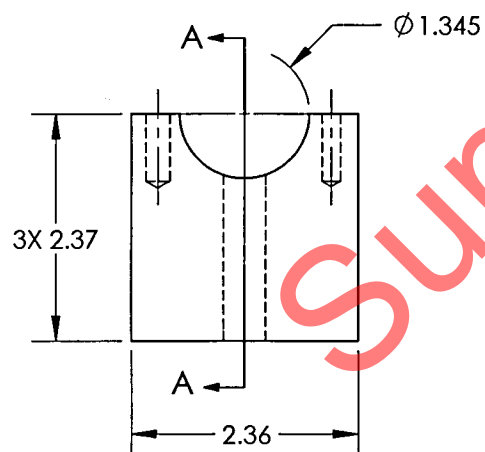
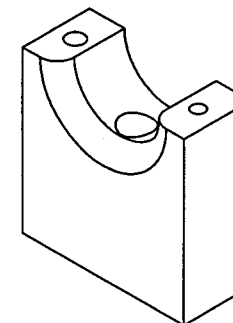
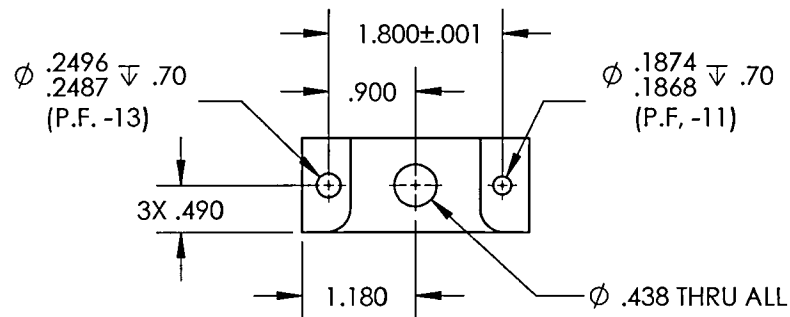
NOTES:

1. REF. AIRBUS T/N: 1120-31502W1.
2. APPLY LOCTITE 620 ONTO MATING SURFACES AND PRESS INTO -1.
3. APPLY LOCTITE 620 ONTO MATING SURFACES AND PRESS INTO -3.

DART AEROSPACE	
TITLE PRESS IN/PUSH OUT DEVICE	
DWG NO. RBE1120-31502W1	REV 1
MAT'L HEAT TREAT FINISH SPEC DRAWN BY: <i>[Signature]</i> CHECKED: <i>[Signature]</i> OPPS APPR: QA APPR: APPROVED: <i>[Signature]</i>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145, EC645
SCALE 1:3	DATE 08/08/2016
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	A36/1018/1020 HR		2
			-3	1	TOP	A36/1018/1020 HR		3
			-5	1	BUSHING 1	O1		4
			-7	1	BUSHING 2	O1		5
			-9	1	PIN	O1		6
		B/O	-11	1	DOWEL PIN, SMALL	STEEL	Ø3/16 X 1-1/4 (MCMaster-CARR # 98381A512)	1
		B/O	-13	1	DOWEL PIN, LARGE	STEEL	Ø1/4 X 1-1/4 (MCMaster-CARR # 98381A544)	1

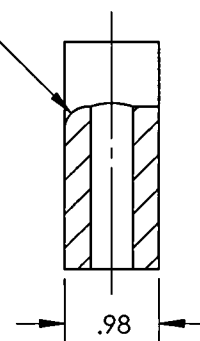
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(-1)

BASE

R.25



SECTION A-A

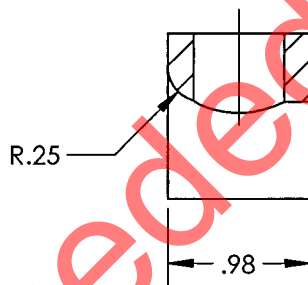
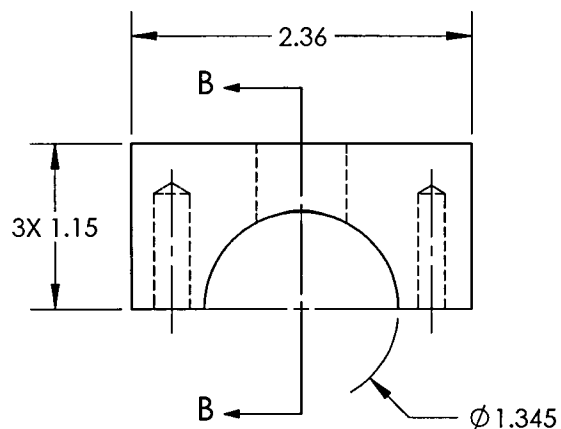
UNDER REVIEW

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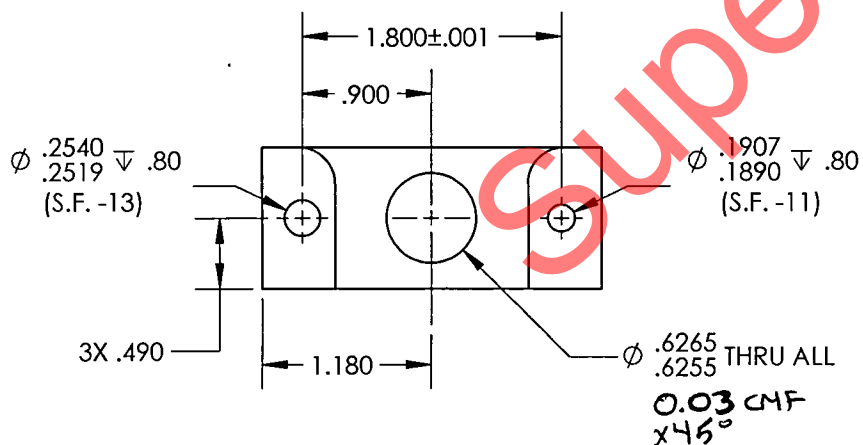
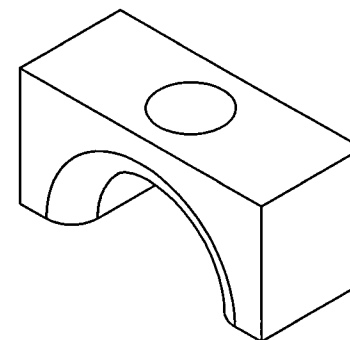


TITLE		PRESS IN/PUSH OUT DEVICE	
DWG NO.	RBE1120-31502W1-1	REV	1
MAT'L	A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		XXX ± .005	FRACTIONS ± 1/8
FINISH	ZINC PLATE	XX ± .01	ANGLES ± .5°
SPEC	ASTM B633 TYPE I SC 2	X ± .1	SURFACES = 125/✓
DRAWN BY:		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
APPROVED:		EC145, EC645	
SCALE	1:2	DATE	09/12/2016
		SHEET 2 OF 6	

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SECTION B-B



③

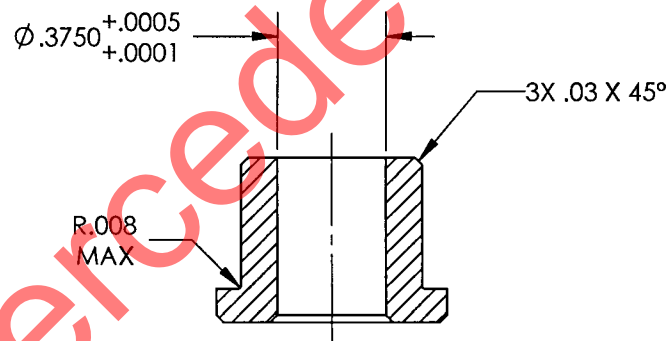
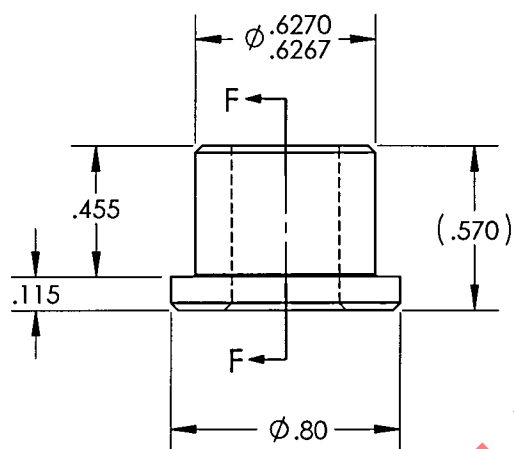
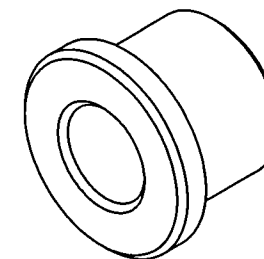
TOP

UNDER REVIEW

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DART AEROSPACE	
TITLE PRESS IN/PUSH OUT DEVICE	
DWG NO. RBE1120-31502W1-3	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/✓
DRAWN BY: [Signature]	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: [Signature]	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: [Signature]	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: [Signature]	USED ON MODEL
APPROVED: [Signature]	EC145, EC645
SCALE 3:4	DATE 09/12/2016 SHEET 3 OF 6

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SECTION F-F

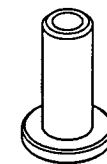
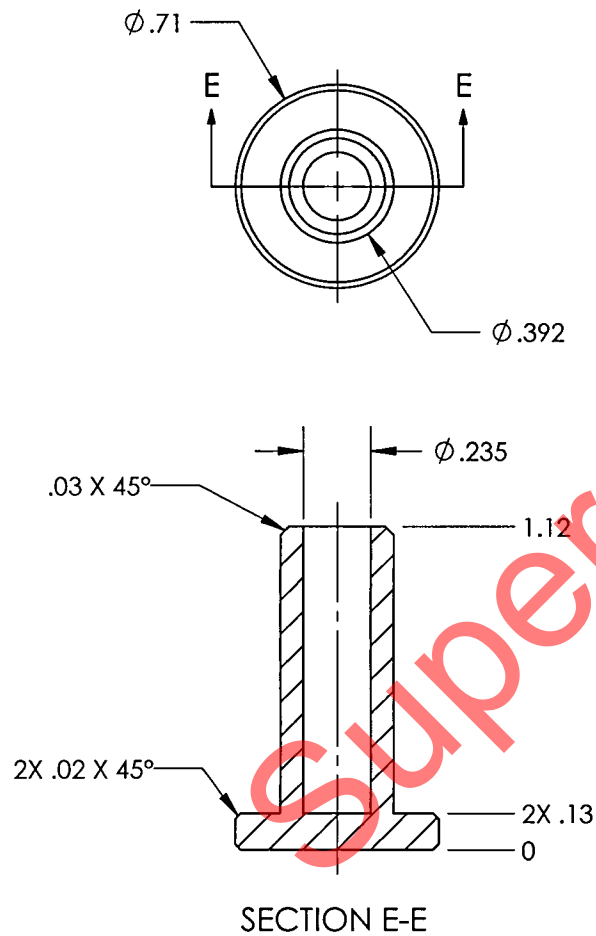
UNDER REVIEW

URF 19-870 19.08.22 KT

(-5)
BUSHING 1

DART AEROSPACE	
TITLE PRESS IN/PUSH OUT DEVICE	
DWG NO. RBE1120-31502W1-5	REV 1
MAT'L O1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: <i>[Signature]</i>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: <i>[Signature]</i>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	USED ON MODEL
APPROVED: <i>[Signature]</i>	EC145, EC645
SCALE 3:2	DATE 09/12/2016
SHEET 4 OF 6	

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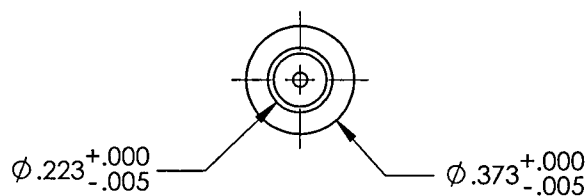
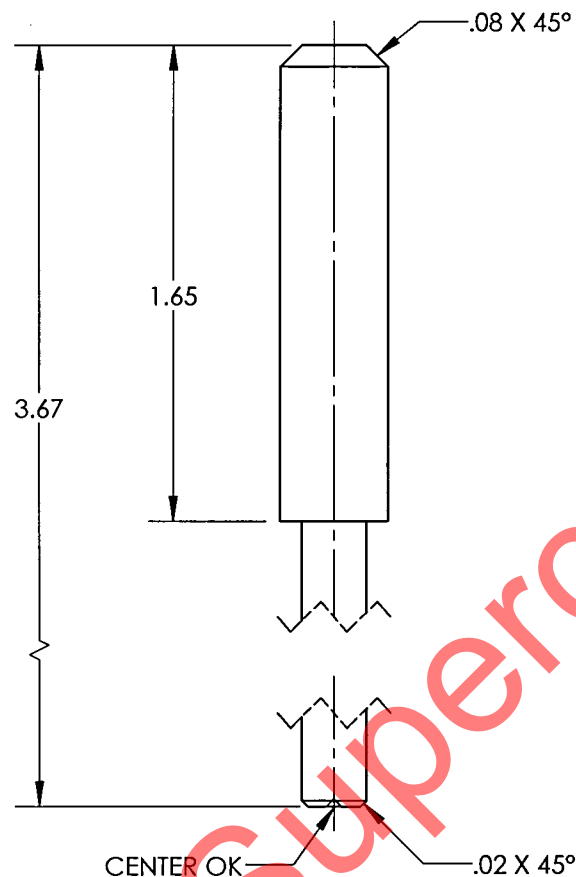
UNDER REVIEW

URF 19-870 19.08.22 KT

(-7)
BUSHING 2

DART AEROSPACE	
TITLE PRESS IN/PUSH OUT DEVICE	
DWG NO. RBE1120-31502W1-7	REV 1
MAT'L O1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: <i>[Signature]</i>	.X \pm .1 SURFACES = 125/✓
CHECKED: <i>[Signature]</i>	1. BREAK ALL SHARP EDGES
OPPS APPR: <i>[Signature]</i>	.015 x 45° OR .015R
QA APPR: <i>[Signature]</i>	2. DIMENSIONAL LIMITS APPLY
APPROVED: <i>[Signature]</i>	AFTER PLATING
SCALE 3:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 09/12/2016	USED ON MODEL
SHEET 5 OF 6	EC145, EC645

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(-9)

PIN

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DART AEROSPACE	
TITLE PRESS IN/PUSH OUT DEVICE	
DWG NO. RBE1120-31502W1-9	REV 1
MAT'L O1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY:	.X ± .1 SURFACES = 125/
CHECKED:	1. BREAK ALL SHARP EDGES
OPPS APPR:	.015 x 45° OR .015R
QA APPR:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 3:2	DATE 09/12/2016
USED ON MODEL EC145, EC645	
SHEET 6 OF 6	